

Work Order ID 83890

83890

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April-27-12 11:12:48 AM

Item ID: D2876 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle Spacer
 Start Date: 27/04/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(83)			
D2876	Rev B								
100		0.00							
100	FLOW WATER JET								B12-5-16
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D 2876 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								B12-5-16
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

counters
(83)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Remove tabs and Tumble								
140		0.00							
140	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
150	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

(83) 7/6 12-5-17

83X 12/05/17

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/04/2012 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 11/05/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

Identify as per dwg & Stock Location: STZO 0.00

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170


QC

Memo

0.00

Quality Control

8/3 soc 12/5/22

12/5/22 
mf 12-05-22

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Picklist Print

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Work Order ID: 83890

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Parent Item: D2876

D2876

Parent Item Name: Saddle Spacer

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

Esr Rev:B00.05.19Added inspect level 8EC

IPP Rev:C Now M6061-T6 06-06-23

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.100

Purchased

No

100

sf

76.4000

0.0516

2.172632

4.5

M6061T6S 100

**

B12-5-16

6061-T6 .100 Sheet

Location

Loc Qty

Loc Code

MAT021

76.4

102201

1

118072

12.4

118523

63

118072

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

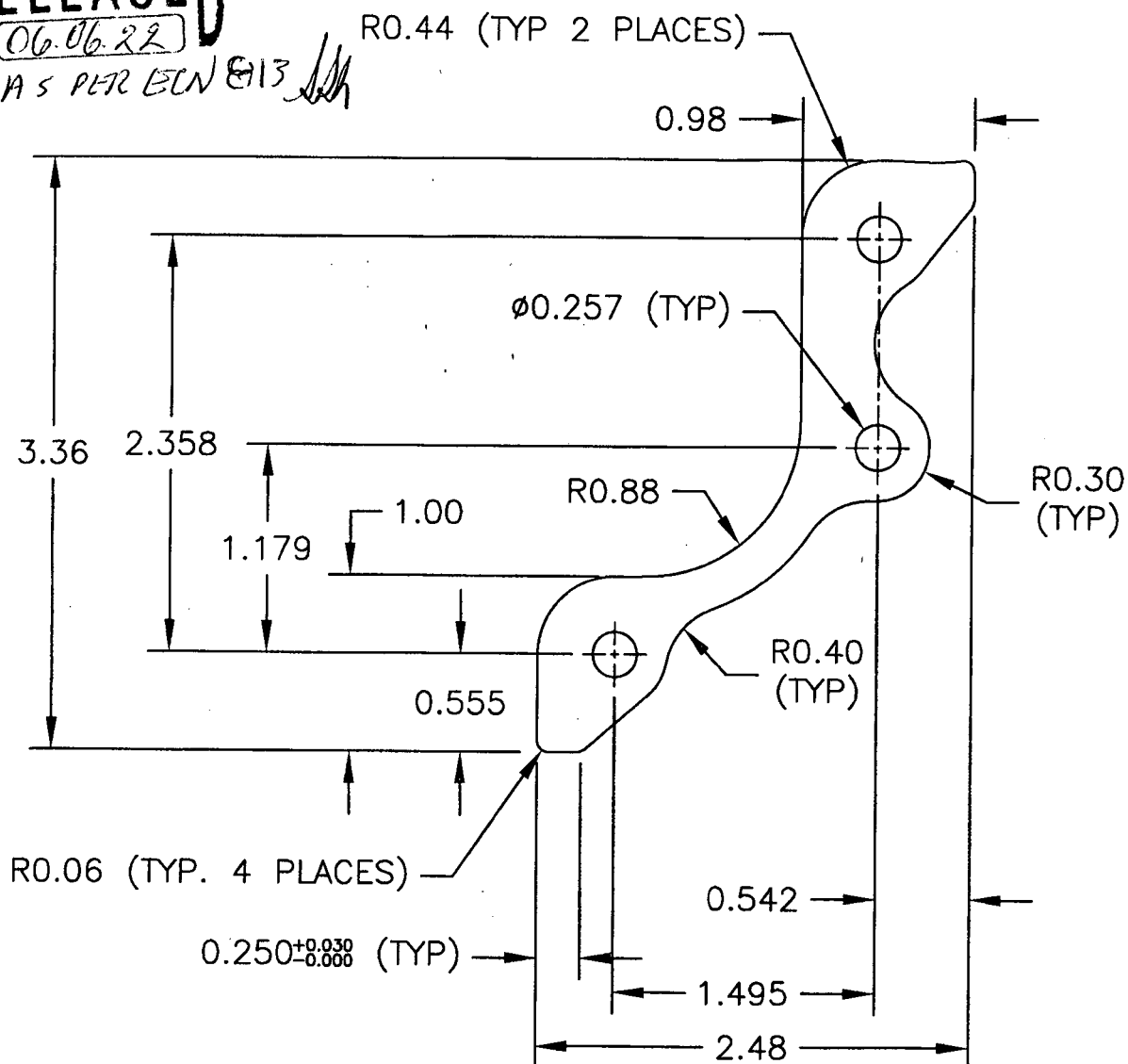
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22AS PER ECN 813 *[Signature]***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23890465
12/01/27

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